

Date: Thursday, 11/12/2008 10:08:17 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARSHOE		
Job Number	: 43991					
Estimate Number	: 10613					
P.O. Number	:			Part Number	: D265615	
This Issue	: 11/12/2008	S.O. No.	:	Drawing Number	: D2656 REV D	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /	Type	: PURCHASED PARTS	Drawing Revision	: D	
Previous Run	: 41125			Material	:	
Written By	:			Due Date	: 22/12/2008	
Checked & Approved By	: <u>JUL 08-12-11</u>			Qty:	10	Um: Each
Comment	: Est: D 02.10.25 Re-format KJ Est Rev:E Now on Waterjet 06-09-25 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M1010S20GA	1010/1025 SHEET	
		Comment: Qty.: 0.6431 sf(s)/Unit Total : 6.4313 sf(s) 1010/1025/A21/6aA SHEET (.040") (M1010S20GA) Batch: <u>109289</u> <u>HB 8-12-18</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2656 Dwg Rev: <u>D</u> <u>HB 8-12-18</u> Prog Rev: <u>D</u>	
		2-Deburr if necessary <u>HB 8-12-18</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>HB 8-12-18</u>	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE 1-Form on Brake as per Dwg D2656 using Jigs DT8261and DT8326 2-Form joggle as per Dwg D2656 using Jig DT8158 3-Identify as D2656-15	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/12/2008 10:08:17 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5-02/01/05 (12)

7.0 POWDER COATING POWDER COATING



m109648

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

(12)

START TIME: 2:35

OVEN TEMPERATURE: 320°

FINISH TIME: 3:05

FZ 09/01/05

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-06-01 (X12)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-20

98

09-06-01

(X12)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Do 09/01/07

MF 08-01-06

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43991
Description: Wearshoe	Part Number:	D2656-15
Inspection Dwg: D2656	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

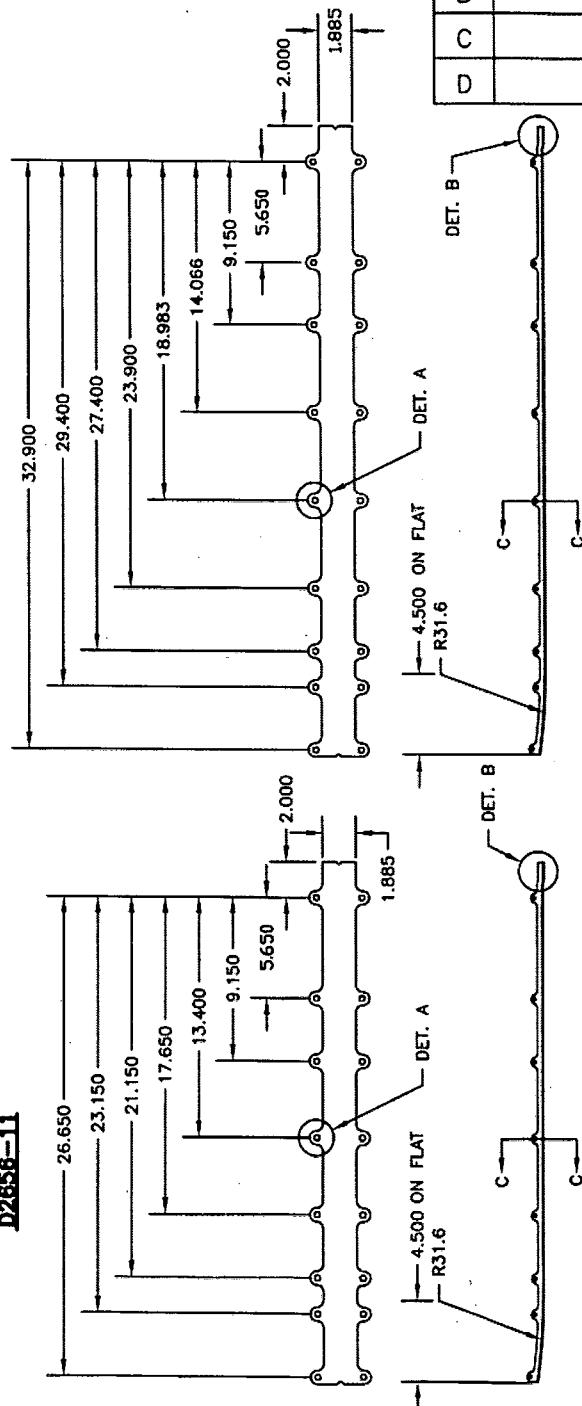
Measured by:	<u>B</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	8-12-18	Date:	08/12/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	E

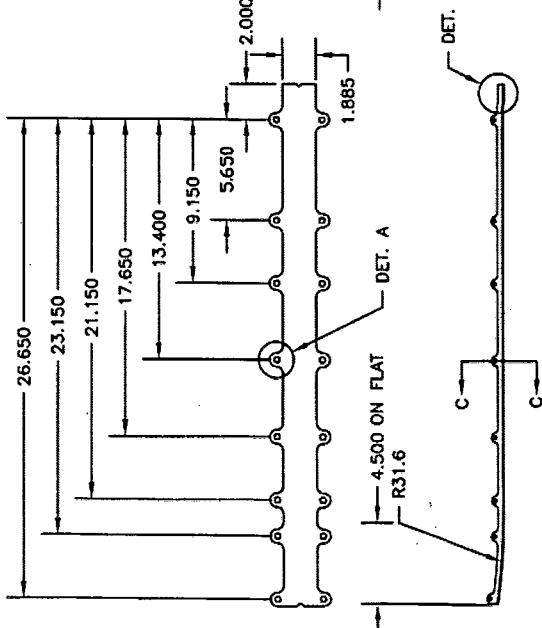
DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. REV. D D2656 SHEET 1 OF 4
DATE		TITLE SCALE 05.08.17 WEARSHOE 1:10
A	97:03:25	NEW ISSUE
B	97:06:02	CHANGED TABS
C	97:06:26	R31.6 WAS R19.5
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT

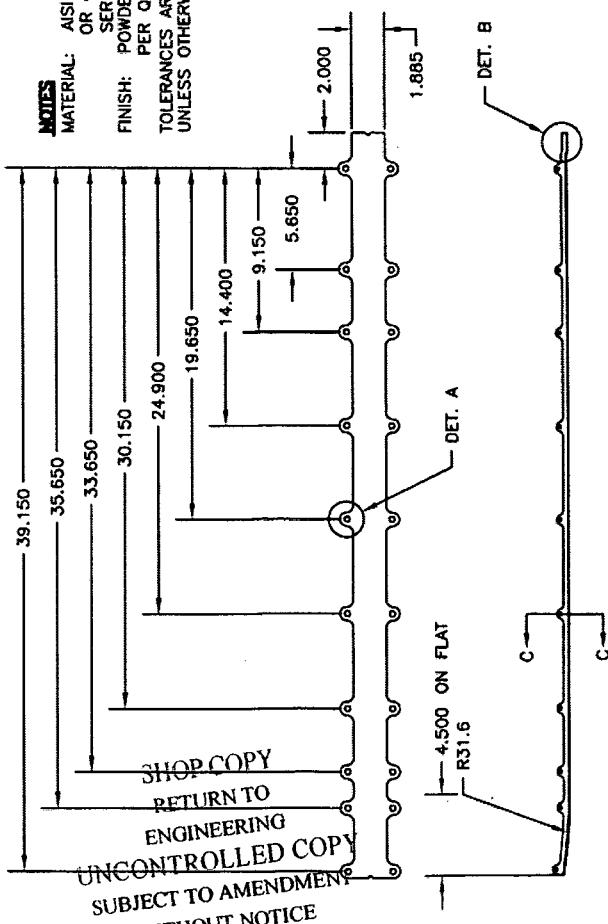
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D2656-11



D2656-15

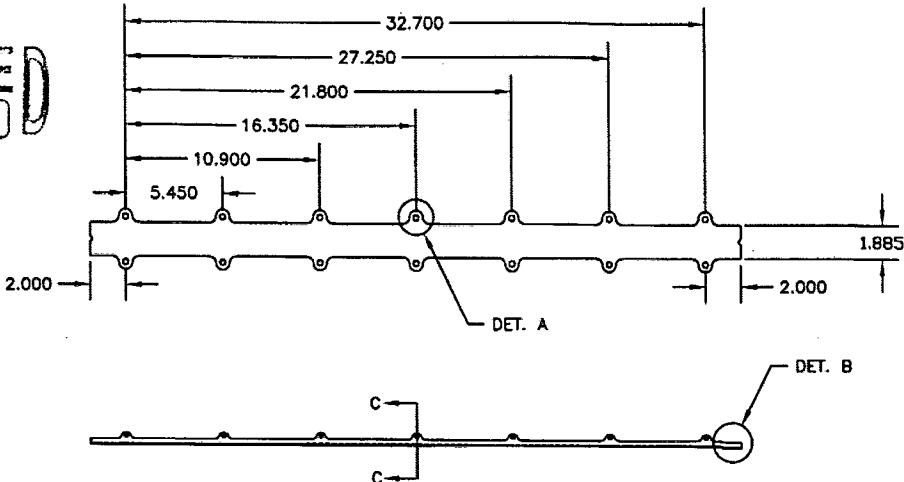
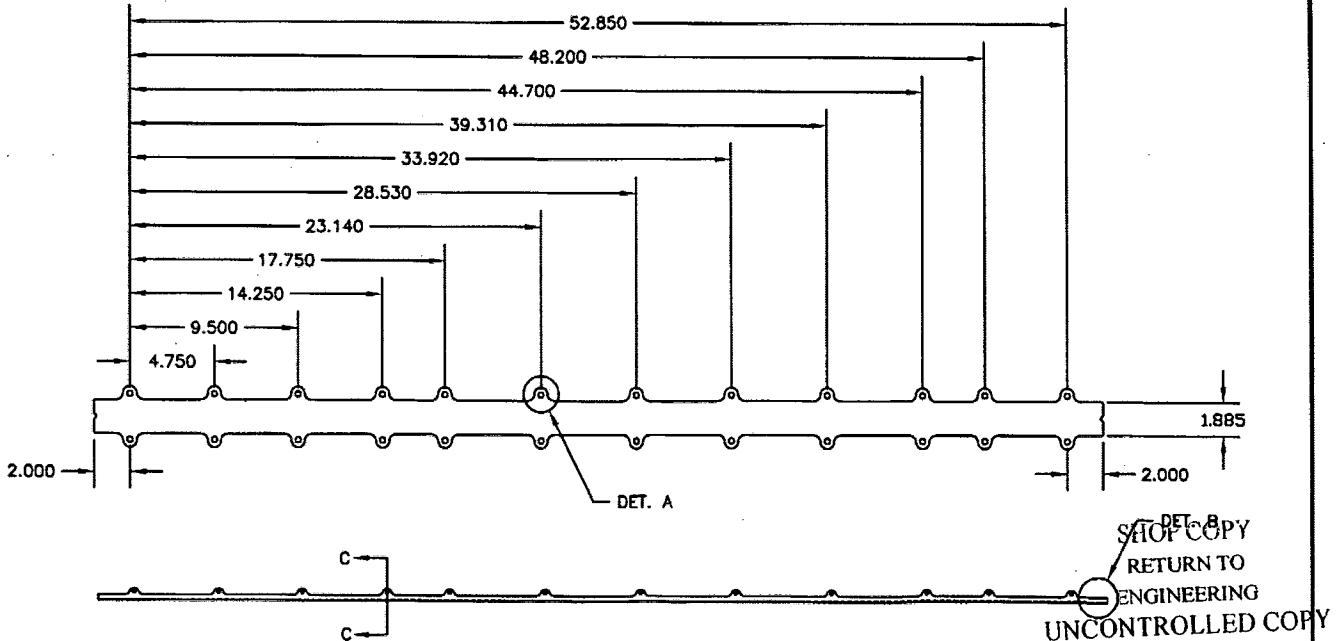


NOTES
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: PONDER COAT GREY SANTEX (.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

RELEASED
05.09.08

DART

DESIGN DS	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>A</i>	APPROVED <i>H</i>	DRAWING NO. D2656
DATE 05.08.17	TITLE WEARSHOE	REV. D SHEET 2 OF 4 SCALE 1:10

D2656-21**RELEASED**
05.01.06**D2656-23****NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W

SERIES STEEL, 20 GAUGE (0.040 THICK)

FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3

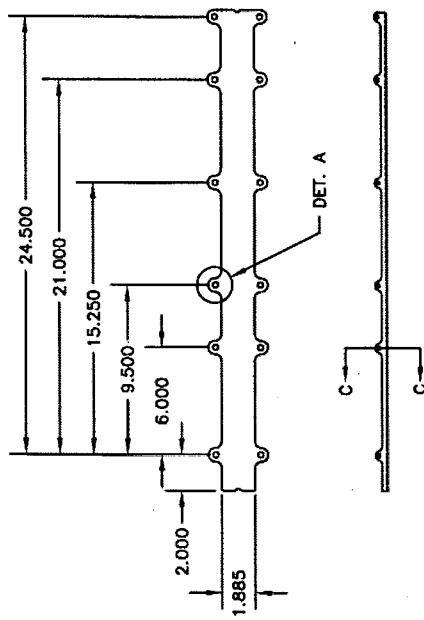
TOLERANCES ARE PER DART QSI 018

UNLESS OTHERWISE NOTED

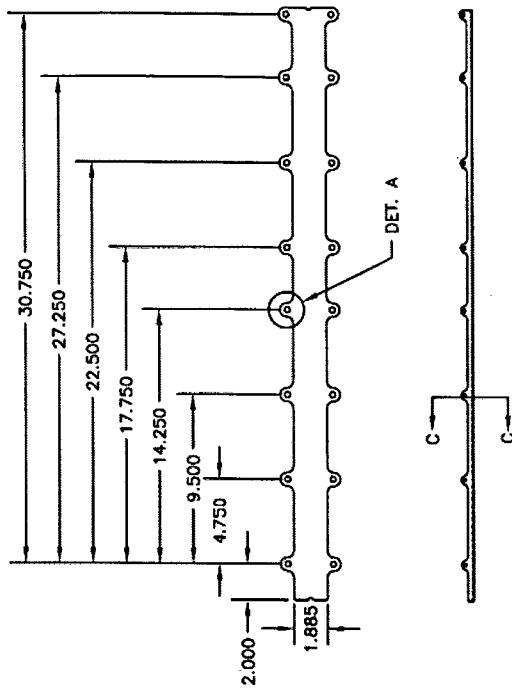


DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
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DATE		REV. D SHEET 3 OF 4
05.08.17		TITLE WEARSHOE SCALE 1:10

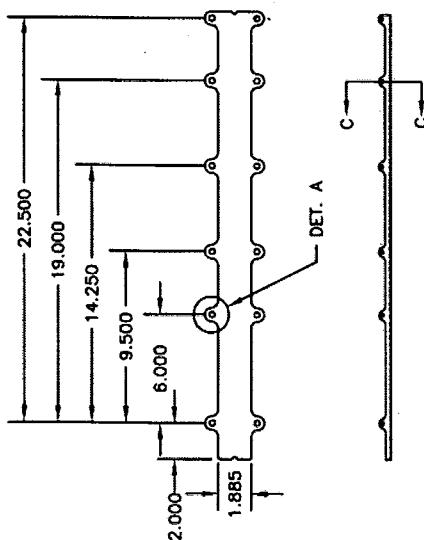
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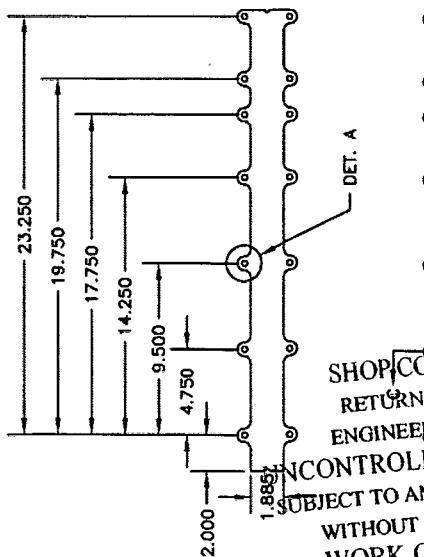
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RELEASED
05.09.06

D2656-31



D2656-35



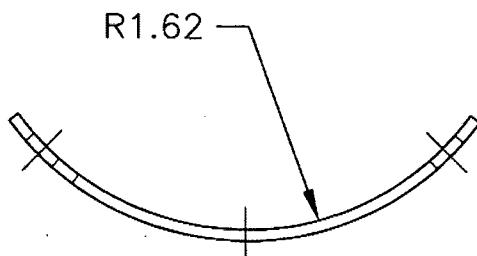
NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES: STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

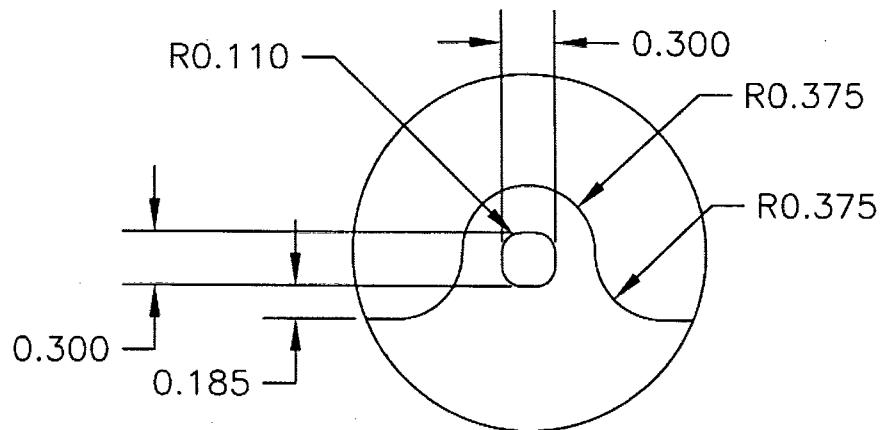
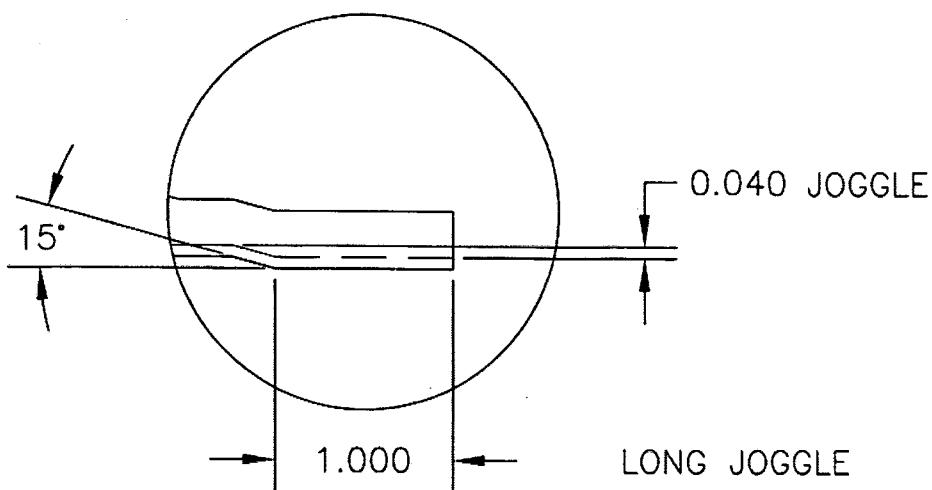
SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
213991

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DESIGN DS	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656	REV. D	SHEET 4 OF 4
DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10	

SECTION C-C

RELEASED
05.09.06

DETAIL ADETAIL B

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